

# Work Order ID 74853

Wednesday, October 12, 2011 9:55:36 AM

**\*74853\***

Page 1

Item ID: D4095-043      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Wearplate Assembly  
 Start Date: 10/12/2011      Start Qty: 10.00      **\*10\***      Cust Item ID:  
 Required Date: 10/19/2011      Req'd Qty: 10.00      **\*10\***      Customer:  
 Reference:

**PRELIMINARY ISSUE**

11.11.02

Approvals:      Process Plan: MF      Date: 11-10-12      Tooling:      Date:      Run Start **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	<u>PB1</u> <u>11.11.02</u>								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4095								
<u>304.063</u>	Dwg Rev: <u>PB1</u>								
	Prog Rev: <u>PB1</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

11-10-12

(10)

11-10-12

-inspect to PB1

Dwg only

8/11/13

(10)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Wednesday, October 12, 2011 9:55:36 AM

Page 2

Stop \*NR2\*

[illegible]

**Dart Aerospace Ltd**

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00		<i>Sulco 121</i>					
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo <i>(look at xl for TRIA (Fit) Sulco 120)</i>	0.00 0.00		<i>inspector 1231</i> <i>Done only</i> <i>Sulco 121</i>					<i>(+10)</i>
180 <b>*180*</b> HandFinish Hand Finishing	Hand Finishing  Memo COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: <i>118662</i>	0.00 0.00							<i>85</i> <i>11-10-25</i> <i>(16)</i>

**Dart Aerospace Ltd**

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<i>ml</i>	<i>11</i>	<i>10</i>	<i>25</i> (10)
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00				<i>11/10/27</i>			<i>100</i>
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>11/11/02</i>

POSITIVE RECALL  
 EFFECTIVE *11-10-27* AUTH *h*  
 RELEASED *bcw* DATE *11.02*  
*11-660*

*11-10-27*  
*(10)*

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, October 12, 2011 9:55:36 AM

Page 1

Work Order ID: 74853

Parent Item: D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 10/12/2011

Required Date: 10/19/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	46.2000	2.275	23.947368			

FB11-10-12

Location

Loc Qty

Loc Code

MAT020

46.2

118964

46.2

118217

32.

118217

(14)

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 74853
Description: WEAR PLATE		Part Number: D4095-043
Inspection Dwg: D4095-3 Rev: PB1		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .19	+.005-.001	.190	✓		V Bo2	
.300	± .010	.300	✓		V	
.300	± .010	.301	✓		V	
2.432	± .010	2.440	✓		V	
3.227	± .010	3.225	✓		V	
4.06	± .030	4.057	✓		V	
4.98	± .030	4.988	✓		V	
8.43	± .030	8.423	✓		PROW502	
2.50	± .030	2.50	✓		V	
11.50	± .030	11.50	✓		P	
6.32	± .030	6.32	✓		V	
3.500	± .010	3.500	✓		V	
21.750	± .010	21.750	✓		T 1301	
12.22	± .030	12.22	✓		T	
6.006	± .010	6.006	✓		T	
12.100	± .010	12.100	✓		T	
21.00	± .030	21.00	✓		T	
6.00	± .030	6.00	✓		T	
30.000	± .010	30.000	✓		T	
36.000	± .010	36.000	✓		T	
38.88	± .030	38.875	✓		T	
.063	± .010	.059	✓		V	

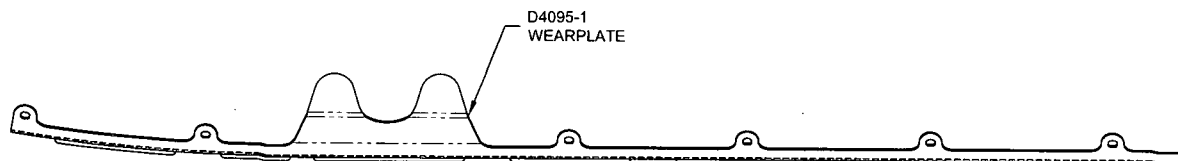
Measured by: PB	Audited by: S	Prototype Approval:
Date: 11-10-17	Date: 11/10/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

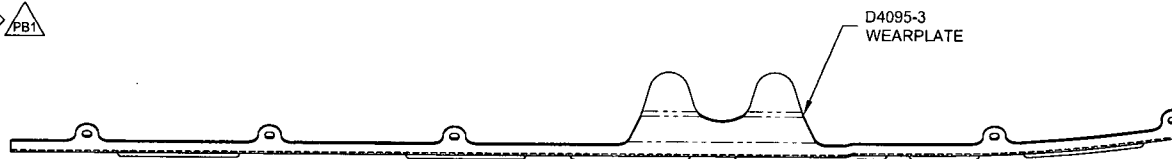
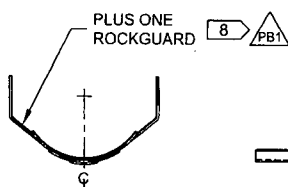
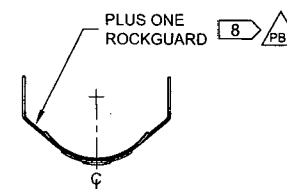
# PRELIMINARY ISSUE

XDF 11.10.11

ITEM	QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
1	X			D4095-041	WEARPLATE ASSEMBLY
2		X		D4095-043	WEARPLATE ASSEMBLY
3			X	D4095-045	WEARPLATE ASSEMBLY
4			1	D3564-5	WEARPLATE
5	1			D4095-1	WEARPLATE
6		1		D4095-3	WEARPLATE
9	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



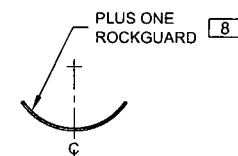
**D4095-041 WEARPLATE ASSEMBLY**



**D4095-043 WEARPLATE ASSEMBLY**



**D4095-045 WEARPLATE ASSEMBLY**



## **D4095-041/-043/-045 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 9) PARTS ARE SYMMETRIC ABOUT

PB1	REVISED D4095-1/-1F/-3/-3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-045 REVISED HARCOAT DESIGN; REVISED NOTE 8.	XDF	11.10.06
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.06		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4095  
REV. PB1  
SHEET 1 OF 5  
TITLE WEARPLATE  
SCALE NTS

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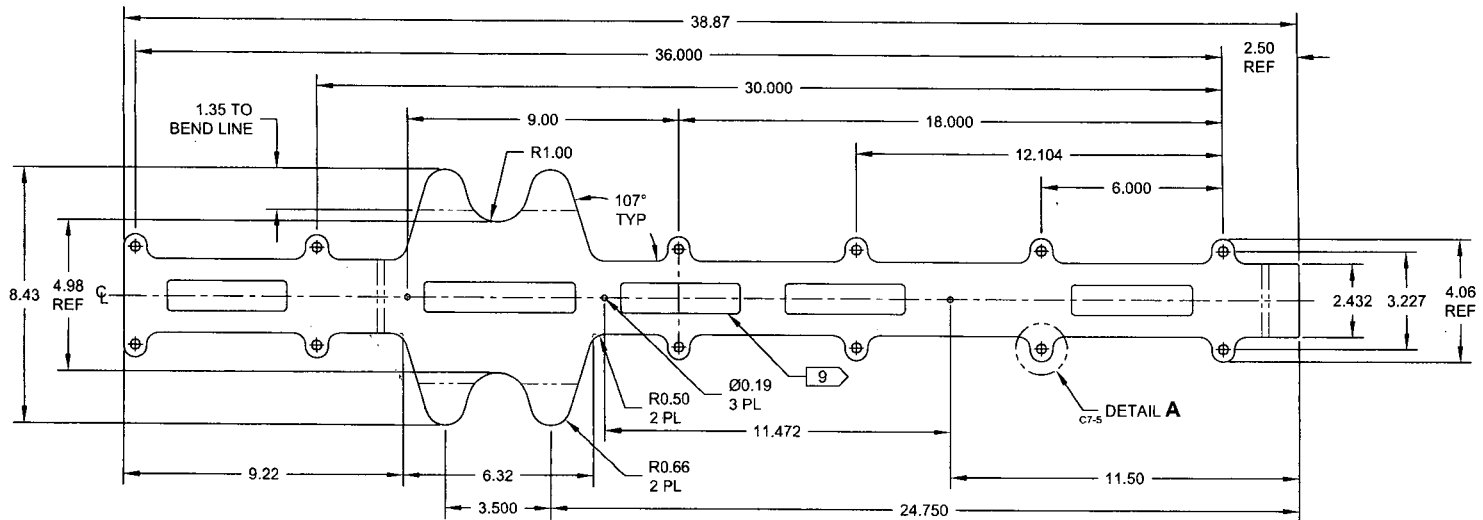
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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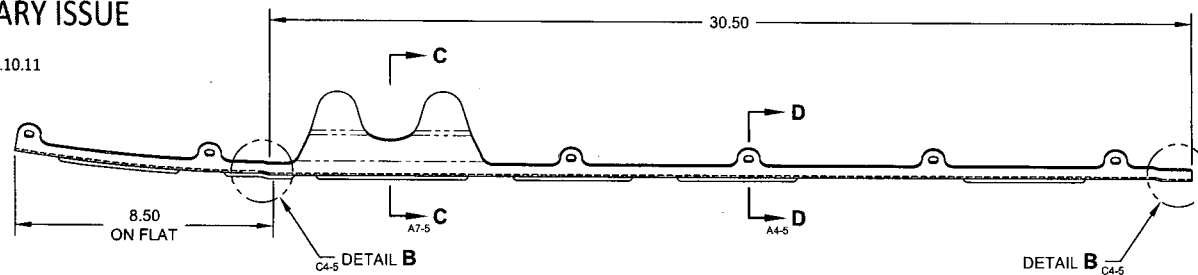
**NOTE:** Date & initial all entries



**D4095-1F FLAT PATTERN** 1

**PRELIMINARY ISSUE**

XDF 11.10.11



**D4095-1 BENDING DETAIL**  
(MAKE FROM D4095-1F)

**D4095-1/-1F/-3/-3F NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240  
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD: WELD AFTER BENDING AS ILLUSTRATED PER DT8308,  
0.13 THICK
- 10) PARTS ARE SYMMETRIC ABOUT C

DESIGN	J	<b>DART AEROSPACE LTD</b>	
DRAWN	XDF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4095	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	11.10.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

# 74853

**Dart Aerospace Ltd**

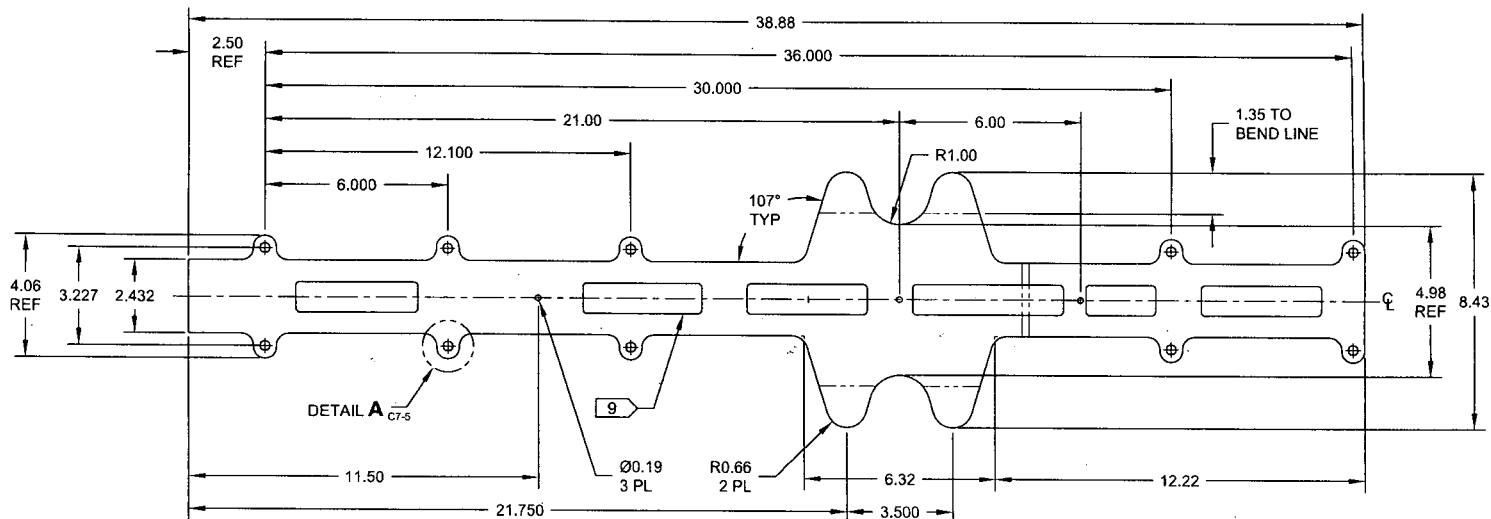
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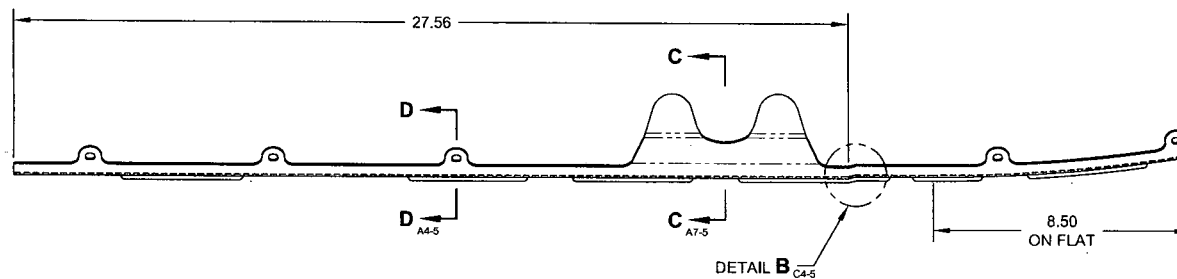
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**D4095-3F FLAT PATTERN** 1



**D4095-3 BENDING DETAIL**  
(MAKE FROM D4095-3F)

**PRELIMINARY ISSUE**

XDF 11.10.11

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN	XDF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PB1
MFG. APPR.		D4095 SHEET 3 OF 5
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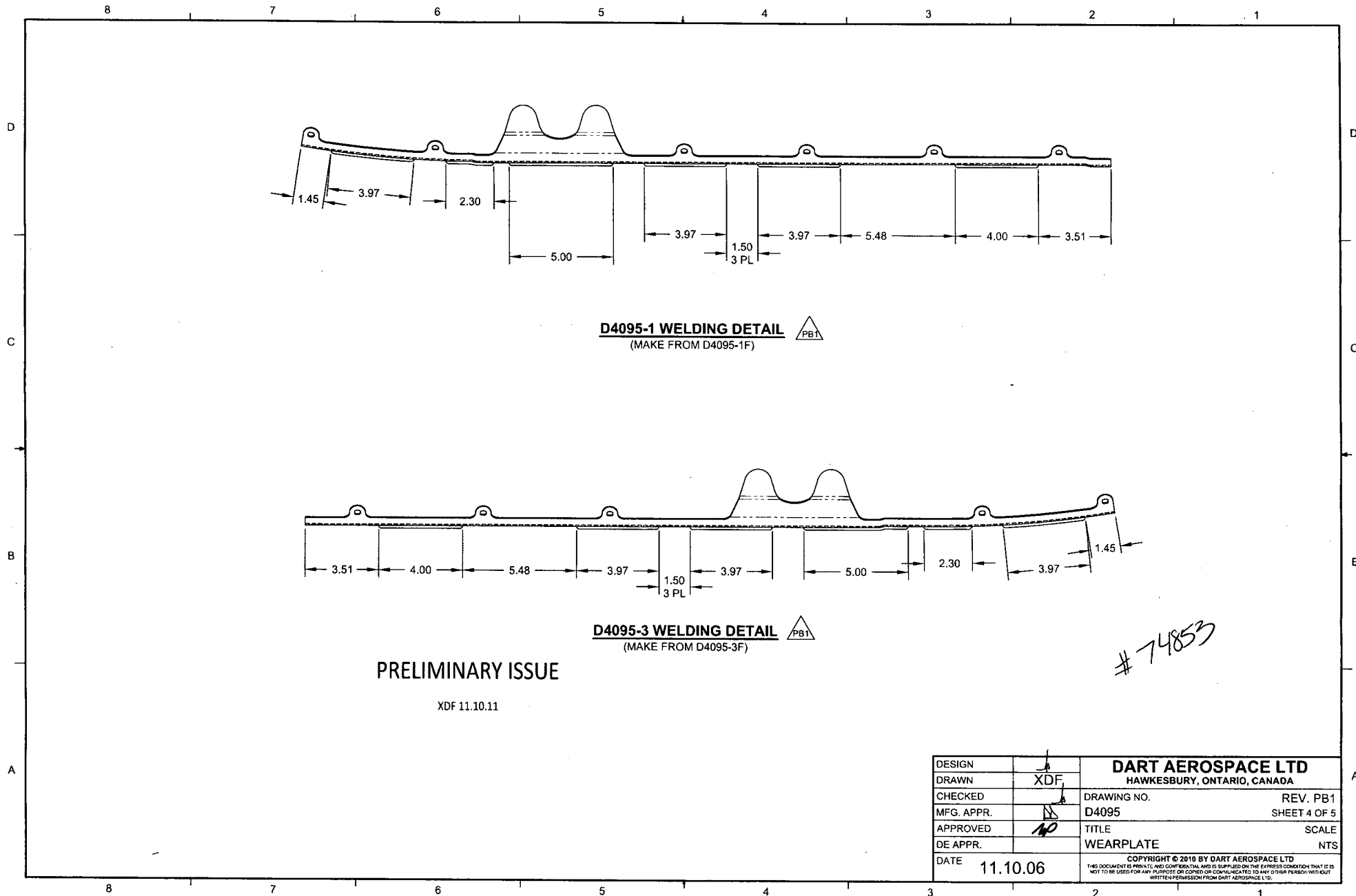
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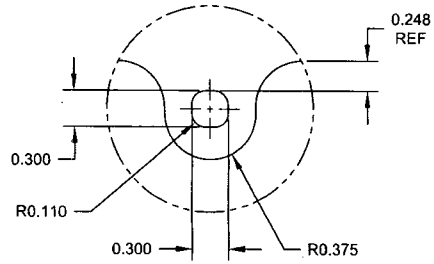
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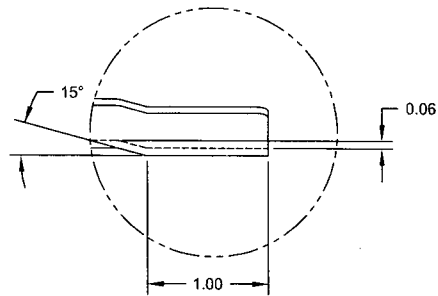
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**DETAIL A: TAB DETAIL**

SCALE 4X  
C3-2  
C6-3

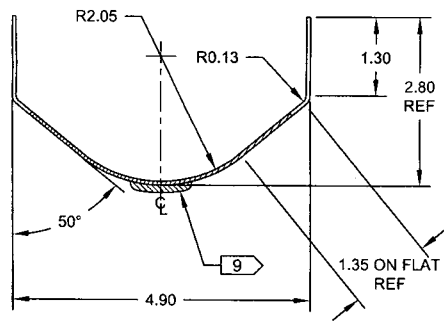


**DETAIL B: JOGGLE DETAIL**

SCALE 4X  
B2-2  
B6-2  
B4-3  
B7-3

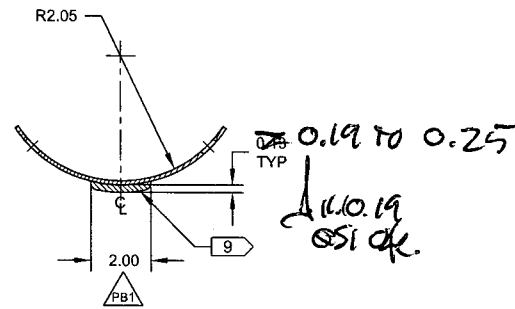
**PRELIMINARY ISSUE**

XDF 11.10.11



**SECTION C-C**

SCALE 2X  
B5-2  
B4-3



**SECTION D-D**

SCALE 2X

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	XDF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4095	SHEET 5 OF 5
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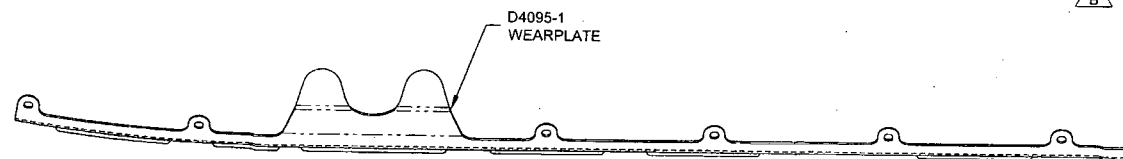
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

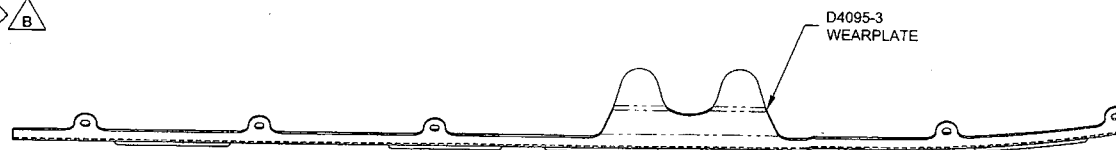
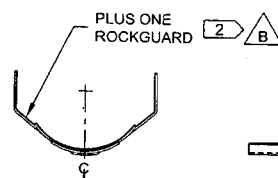
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

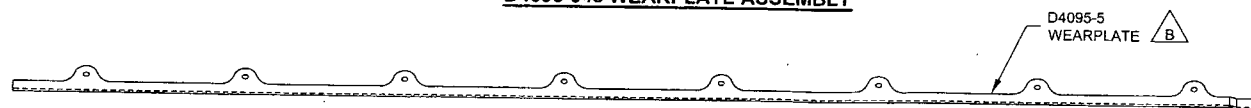
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



**D4095-041 WEARPLATE ASSEMBLY**



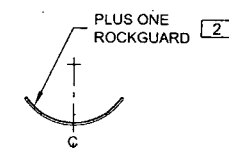
**D4095-043 WEARPLATE ASSEMBLY**



**D4095-045 WEARPLATE ASSEMBLY**

*74853*

RELEASED  
2011-10-31



**D4095-041/-043/-045/-047/-049/-051 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED	<i>140</i>		
MFG. APPR.	<i>140</i>		
APPROVED	<i>140</i>		
DE APPR.	<i>140</i>		
DATE	11.10.18		
<b>DART AEROSPACE USA, INC</b> KENT, WA DRAWING NO. D4095 TITLE WEARPLATE SCALE NTS REV. B SHEET 1 OF 8 COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			